

Date: Wednesday, 1/9/2008 3:56:18 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 BEARPAW INSTALLATION KIT (48")
Job Number	: 36690		
Estimate Number	: 12283		
P.O. Number	:	Part Number	: D205564011
This Issue	: 1/9/2008 S.O. No. :	Drawing Number	: D2521
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: J
Previous Run	: 35062	Material	:
Written By	:	Due Date	: 1/31/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>08.01.09</u>		
Comment	: Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC Est Rev:G 06-08-28 As per Rev E JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

08/02/04

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 13.6500 sf(s)/Unit Total : 68.2500 sf(s)
 blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: M106161 DIP 08/01/30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

DIP/J.L.

08/02/01

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. 08/02/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/9/2008 3:56:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 36690

Part Number: D205564011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

R.O. 08/02/01

HHH

6.0	D2182B	Neoprene Cushion-.750 bl
-----	--------	--------------------------



Comment: Qty.: 3.7000 f(s)/Unit Total : 18.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion 34777

AS

08/02/04 (X5)

HHH

7.0	D2274	Radius Block
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Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block 35205

AS

08/02/04 (X5)

HHH

8.0	D2529	Washer
-----	-------	--------



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer 35356

AS

08/02/04 (X5)

HHH

9.0	D2947	Clamp
-----	-------	-------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp 32859

AS

08/02/04 (X5)

HHH

10.0	D3544041	CLAMP
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

CLAMP

Batch: 35088 x7 B36760 x13

AS

08/02/04 (X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 08/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/9/2008 3:56:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 36690

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Batch: M106815

AS

08/02/04

(X5)

12.0

AN415A

Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN4-15A

Bolt

M106375

AS

08/02/04

(X5)

13.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN960JD416

Washer

M106700

AS

08/02/04

(X5)

14.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Nut

Batch: M105938

AS

08/02/04

(X5)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/02/04 (X5)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: C

8/2/4

500

(52)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36690
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.260	✓			
B	0.90	0.96	0.925	✓			
C	0.27	0.330	0.310	✓			
D	0.470	0.530	0.500	✓			
E	21.740	21.760	21.750	✓			
F	0.72	0.780	0.751	✓			
G	0.35	0.410	0.379	✓			
H	11.490	11.570	11.500	✓			
I	3.41	3.47	3.435	✓			
J	11.790	11.810	11.800	✓			
K	9.47	9.53	9.500	✓			
L	7.190	7.210	7.200	✓			
M	6.910	6.970	6.94	✓			
N	44.47	44.530	44.500	✓			
O	6.590	6.650	6.620	✓			
P	0.940	0.980	0.953	✓			
Q	18.97	19.03	19.00	✓			
R	0.350	0.410	0.380	✓			
S	0.740	0.780	0.755	✓			
T	0.240	0.280	0.255	✓			
U	0.370	0.410	0.375	✓			
V	0.740	0.780	0.748	✓			
W	0.740	0.780	0.758	✓			

Measured by:	DJP/J.L
Date:	08/01/31

Audited by:	S.F
Date:	08/01/31

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28	TITLE 205 BEARPAW		SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 36690

RELEASED

06 08.23 #

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

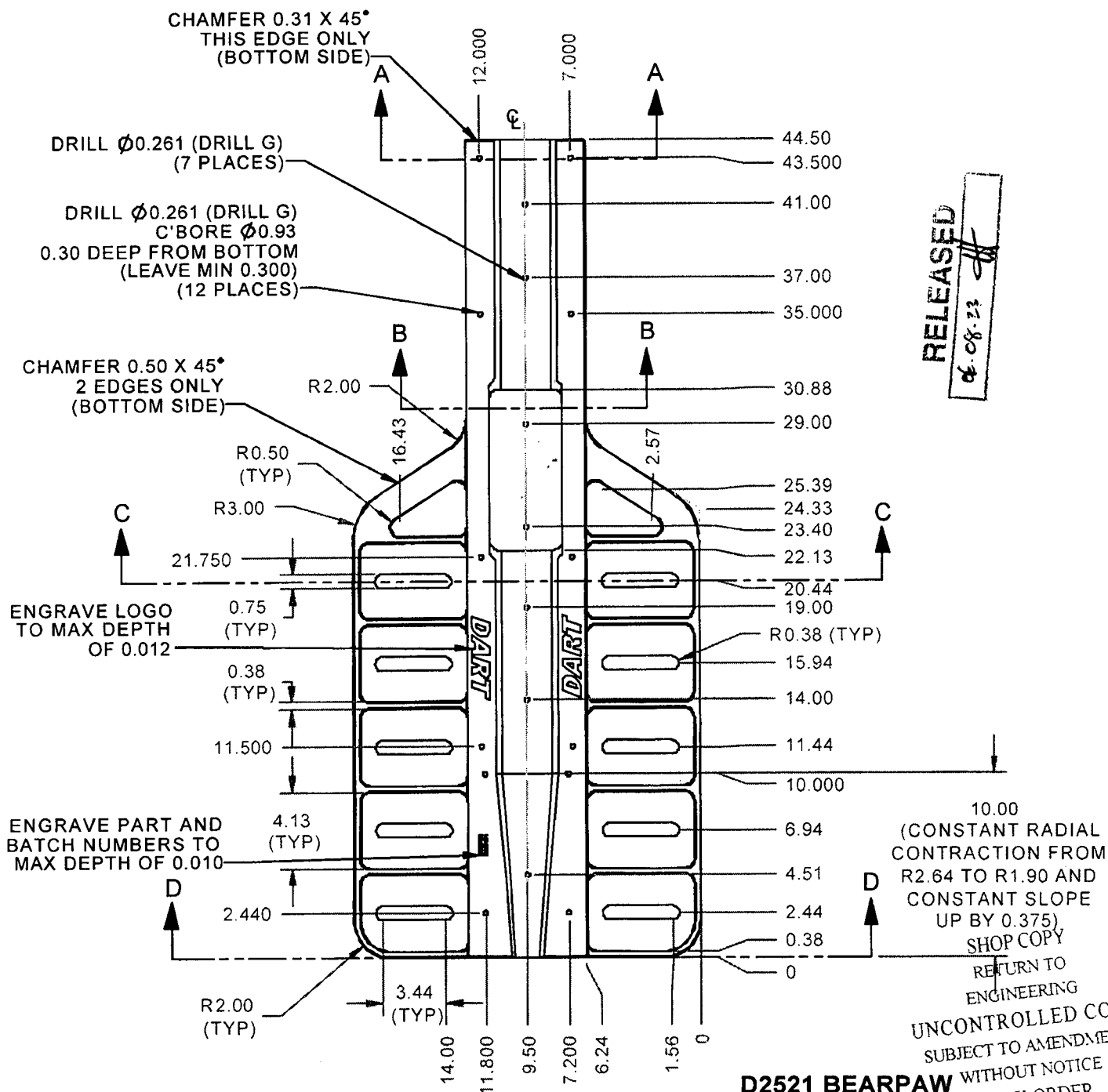
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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN 	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2521	REV. J SHEET 2 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE 1:8



NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
6) PART IS SYMMETRIC ABOUT C

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

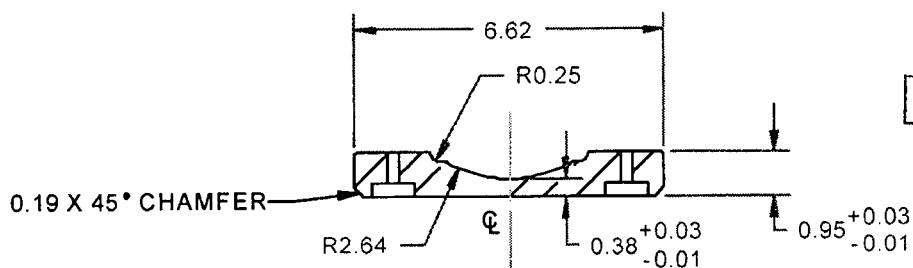
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



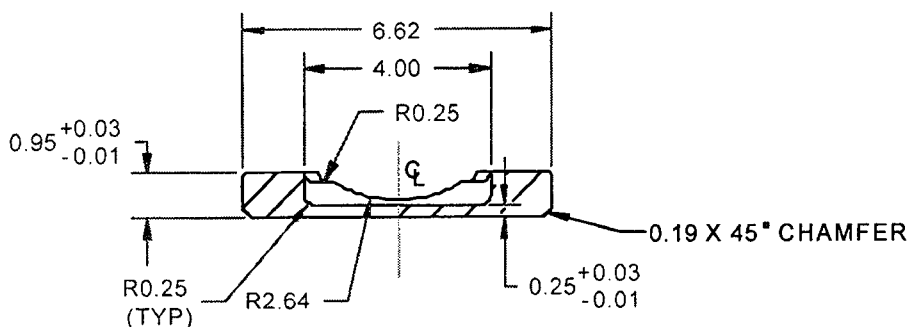
DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 3 OF 3	
		SCALE 1:4	



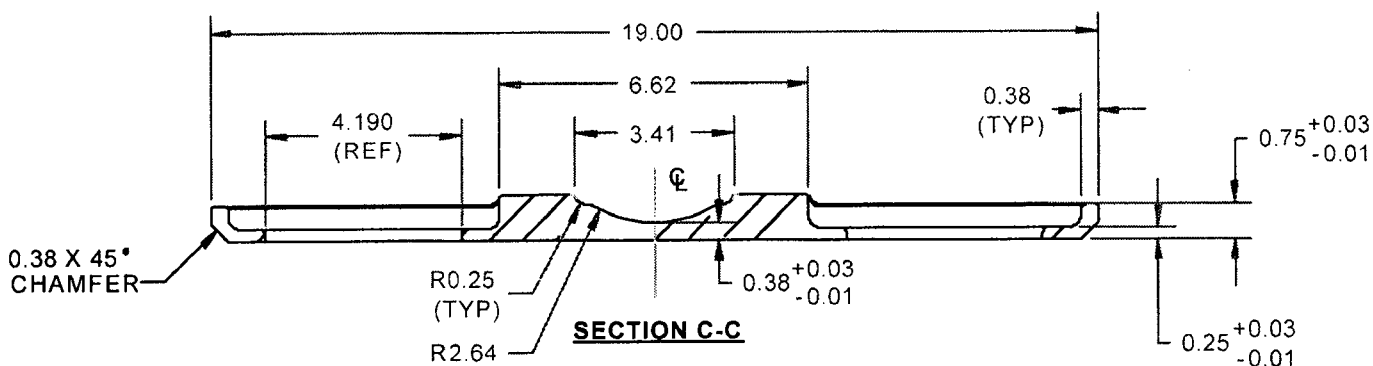
RELEASED

06.08.23 #

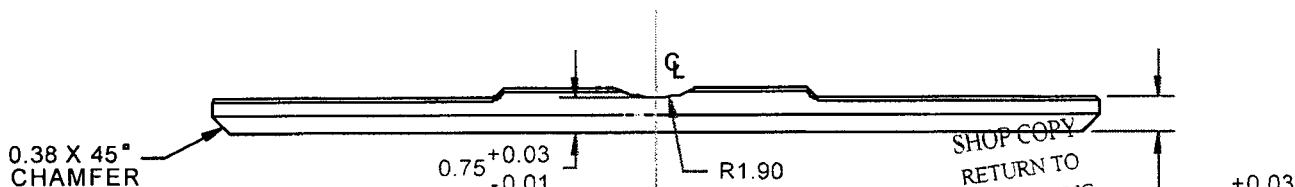
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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WITHOUT NOTICE
WORK ORDER
NO. 36690

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

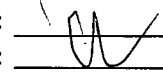
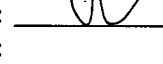
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 07/12/2007 1:54:25 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D205-564 UPDATE PAPERWORK
Job Number : 36198	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z_CUSTOM
This Issue : 07/12/2007 S.O. No. : N/A	Drawing Number : ECN 1079
Prsht Rev. : N/A	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : 	Due Date : 14/12/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK:

D205-564-011 BEARPAW KITS

ADD NEW PAPERWORK TO KITS

TC STC SH96-42, ISSUE 4, PER ENC 1079

RETURN TO STK

006 (1x) 008 (9x) (5x) (10x)
 27314 - 30338 35062 32835

7/12/11 54 (25x)

2.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

(25)
 02/12/11

Job Completion



11 07-12-11

Friday, 04/04/2008 2:47:06 PM
Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: UPDATE PAPERWORK
Job Number	: 38417		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D205564011
This Issue	: 04/04/2008 S.O. No. :	Drawing Number	: ECN1170
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: <u>mf</u>	Due Date	: 11/04/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
PULL FROM STOCK
D205-564-011 B



B35062	B36690
B35062	B36690
B35062	B32835
B35062	B32835
B35062	B32835
B32835	B32835
B32835	B32835
B36690	
B36690	
B36690	

ADD TO KITS IN STOCK FAA STC SR00571NY
FMS TO BE REINSTATED
PER ECN1170

RETURN KITS TO STOCK

update completed
(X17) 08/04/08

2.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE



08/04/14

Job Completion



mf 08-04-10
W